ASAP stop 10/02 latest

Work Order ID 51114

August 4, 2009 11:04:35 AM

Split (1)

Item ID: D3041-3 **Accept** **Setup Start**

Revision ID: C **Stop**

Item Name: Clamp

Start Date: 8/07/09 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 8/21/09 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 09-08-30 **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3041	Rev C								
100	BAND SAW	0.00				37			
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut D2423 Extrusion: 1.250" Long								
110	HAAS CNC VERTICAL MACHINING #1	0.00				30	7		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Check for cracks while loading into the machine |Machine as per Folio FA153 and Dwg D3041 |Tumble and Deburr rough edges after tumbling| Identify as D3041-3								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				30	0		
QC	**Memo**	0.00							
Quality Control									

09/08/04

09/08/05

09/08/05



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Item ID: D3041-3
Revision ID: C
Item Name: Clamp

Start Date: 8/07/09 **Start Qty:** 20.00
Required Date: 8/21/09 **Req'd Qty:** 20.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

=> JK 09/08/07 30 0

140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

=> JK 09-08-10 X30

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating									

M112260

Mask inside of 0.8120" diameter hole START TIME: 1:45pm OVEN TEMPERATURE: 2:15pm FINISH TIME: 320°F

=> JK 09-08-10 X30

Work Order ID 51114

August 4, 2009 11:04:35 AM

Item ID: D3041-3
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Start Date: 8/07/09 **Start Qty:** 20.00
Required Date: 8/21/09 **Req'd Qty:** 20.00
Reference:

Cust Item ID:
Customer:

Accept **Setup Start** **Stop**

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
170 Small Fab Small Fab	Small Fab	0.00							
	Memo	0.00							
	1- Press D2611 bearing into lug as per Dwg D3041 2- Stake bearing into place as per Dwg D3041 3-Touch up stake marks with white emeron paint **~~PLEASE SEE JASON BEFORE PRESSING BEARINGS FOR NEW TOOLING **~~								
180 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							

Work Order ID 51114

August 4, 2009 11:04:35 AM

Item ID: D3041-3
Revision ID: C
Item Name: Clamp

Start Date: 8/07/09 **Start Qty:** 20.00
Required Date: 8/21/09 **Req'd Qty:** 20.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging Packaging	Identify as per dwg & Stock Location:_____	0.00			9/8/11	(4x)	50		
	Memo	0.00							
200 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

09-08-11

MF 09-08-11

Picklist Print

August 4, 2009 11:04:35 AM

Work Order ID: 51114

Parent Item: D3041-3RevC

Parent Item Name: Clamp

Comments:

Start Date: 8/07/09 **Required Date:** 8/21/09

Start Qty: 20.00 **Required Qty:** 20.00

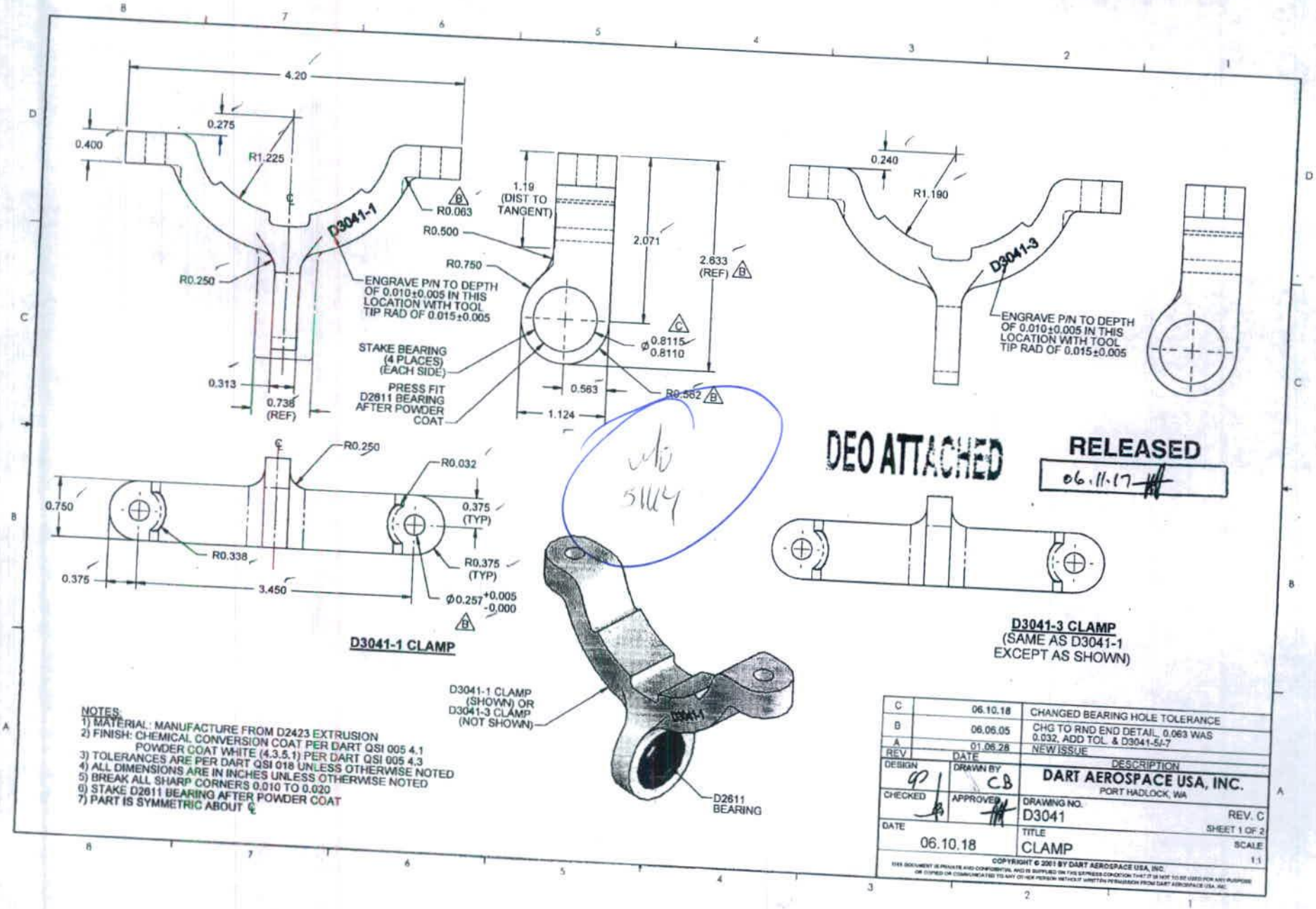
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2611RevC Bearing		Manufactured	No			100	Each	37.0000	20.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	37	
46841	8	
50521	29	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423RevB1 Lug Extrusion		Manufactured	No			170	f	760.9447	2.1937	4	SS 09/05/11	

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	760.94468	
43722	213.01468	
44529	22.39	
45800	525.54	DSP 9/08/05

3,854 (F) ✓


4.20
0.275
0.400
R1.225
D3041-1
R0.063
R0.250
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005
1.19 (DIST TO TANGENT)
R0.500
R0.750
2.071
2.633 (REF)
STAKE BEARING (4 PLACES) (EACH SIDE)
PRESS FIT D2611 BEARING AFTER POWDER COAT
Ø0.8115 0.8110
0.313
0.738 (REF)
0.563
R0.562
1.124
0.240
R1.190
D3041-3
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005
DEO ATTACHED
RELEASED
06.11.17
R0.250
R0.032
0.750
0.375 (TYP)
R0.338
R0.375 (TYP)
0.375
3.450
Ø0.257 +0.005 -0.000
D3041-1 CLAMP
D3041-3 CLAMP
(SAME AS D3041-1
EXCEPT AS SHOWN)
D3041-1 CLAMP (SHOWN) OR D3041-3 CLAMP (NOT SHOWN)
D2611 BEARING
NOTES:
1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
6) STAKE D2611 BEARING AFTER POWDER COAT
7) PART IS SYMMETRIC ABOUT ℄
C 06.10.18 CHANGED BEARING HOLE TOLERANCE
B 06.06.05 CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5/-7
A 01.06.28 NEW ISSUE
REV DATE DESCRIPTION
DESIGN QP
DRAWN BY C.B
CHECKED
APPROVED
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. D3041
REV. C
SHEET 1 OF 2
DATE 06.10.18
TITLE CLAMP
SCALE 1:1
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.

DART AEROSPACE LTD

Description: clamp	Work Order: 5114
Inspection Dwg: D3041 Rev: C	Part Number: D3041-3
	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	± .030	4.205	✓			
.100	± .010	.395	✓			
1.190	± .010	1.190	✓			
.250	± .010	.250	✓			
.313	± .010	.313	✓			
.063	± .010	.063	✓			
.750	± .010	.756	✓			
.375	± .010	.375	✓			
3.450	± .010	3.450	✓			
.257	+.005 -.001	.258	✓			
.375	± .010	.275	✓			
.375	± .010	.376	✓			
1.124	± .010	1.124	✓			
.563	± .010	.563	✓			
.811	+.005 / -.000	.811	✓			
2.633	± .010	2.633	✓			
2.071	± .010	2.072	✓			

Measured by:	JL
Date:	09/08/04

Audited by:	[illegible]
Date:	09/08/07

Prototype Approval:	N/A
Date:	N/A

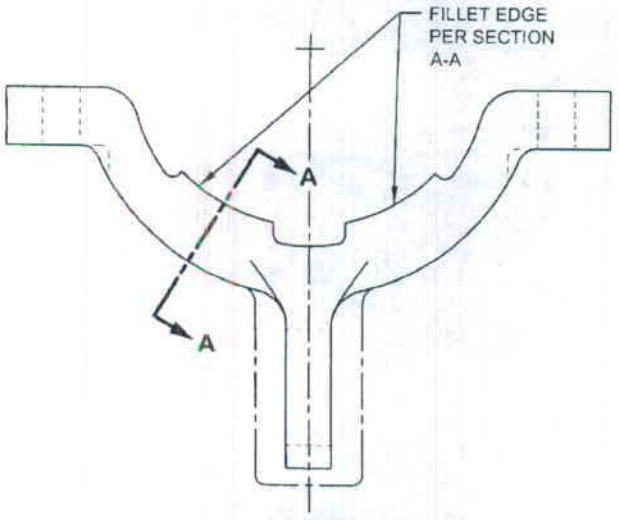
Date	Change	Revised by	Approved
	New Issue	KJ/JLM	

(20)

DRAWING NO.	TITLE	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D3041	CLAMP	-		D3041-C-1	SHEET 1 OF 1	NTS

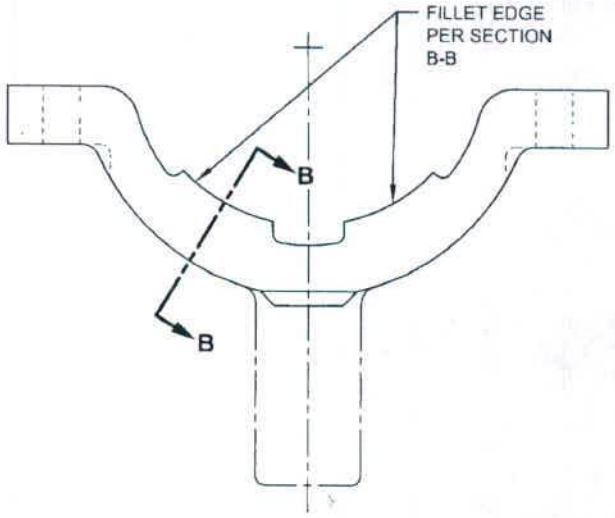
DRAWN	CHECKED	MFG. APPR	APPROVED	DE APPR.
NJS			MJR	
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



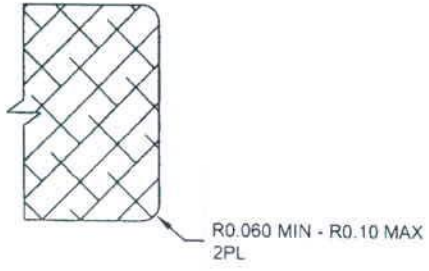
D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



SECTION A-A
SCALE 2X

SECTION B-B
SCALE 2X

RELEASED
09/07/07

SEE PAR 122 FOR FURTHER DETAILS

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